

Date: Thursday, 6/15/2006 1:56:14 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER		
Job Number	: 27590D		Part Number	: D30657		
Estimate Number	: 10380		Drawing Number	: D3065 REV. A2		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 6/15/2006 S.O. No. : N/A		Drawing Revision	: A2		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: 6/15/2006 Type : SMALL /MED FAB		Due Date	: 7/2/2006 Qty: 60 Um: Each		
Previous Run	: 26928D					
Written By	:					
Checked & Approved By	:					
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF					
	Est Rev:D Now on Water Jet 06-04-11 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet Comment: Qty.: 0.1653 sf(s)/Unit Total : 9.9162 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: 060417
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3065 Dwg Rev: A2 Prog Rev: A2 2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.07.11	2	1 part SCRAP. minor delamination on one hole on the waterjet.	SAM 06/07/11	destroy.	06.07.11	J	OSD/M 06.07.11	J

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes NoDQA:

Date: 06/08/11

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 6/15/2006 1:56:14 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 27590D

Part Number: D30657

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

SB 06/08/17 59

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 06/08/29 59

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

10/06/29 (58)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STEPS 121

10/06/30 59
LB 06/08/30 (59)

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

59
DL 06/08/31

Job Completion



(Y06108130)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. A D3065 SHEET 1 OF 5
DATE	02.09.11	TITLE SCALE STEP LEG ASSEMBLY 1:2

RELEASED
02.01.20

~~UNDER REVIEW~~

C6.06 02.CB
material change

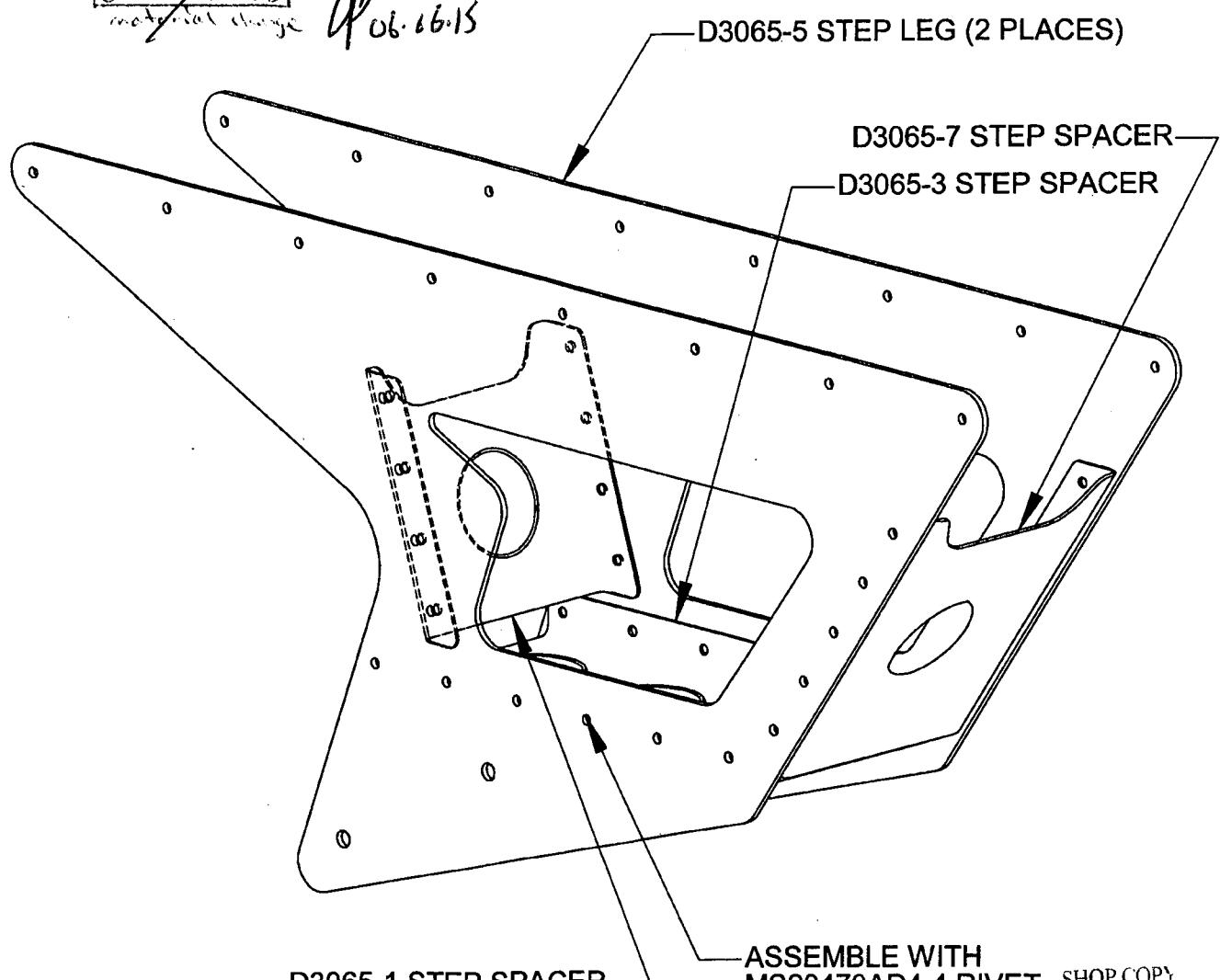
UP 06.16.15

02.01.20

A 02.09.11 NEW ISSUE

A1 03.02.13 (P) ADD SLOTS TO D3065-5

A2 03.02.27 (P) 0.51 WAS 0.410



D3065-041 STEP LEG ASSEMBLY

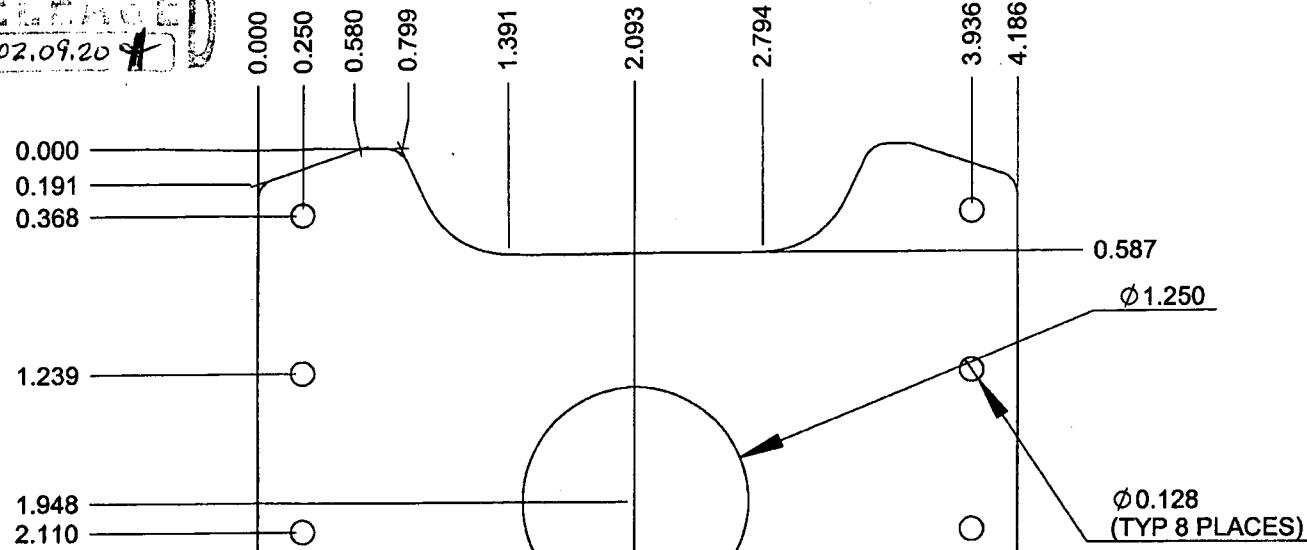
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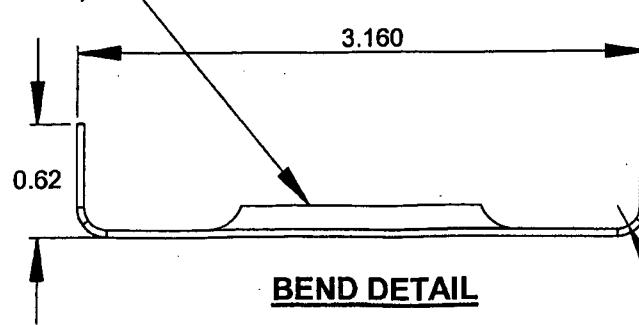
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CHECKED	APPROVED	DRAWING NO.	REV. A
DATE	02.09.11	D3065	SHEET 2 OF 5

SCALE
1:1**RELEASED**
02.09.20**UNDER REVIEW**C6.66.22 CB
material change

OK JP 06.06.15



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R0.125 (TYP)
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WORK ORDER

NO. 27590 D

D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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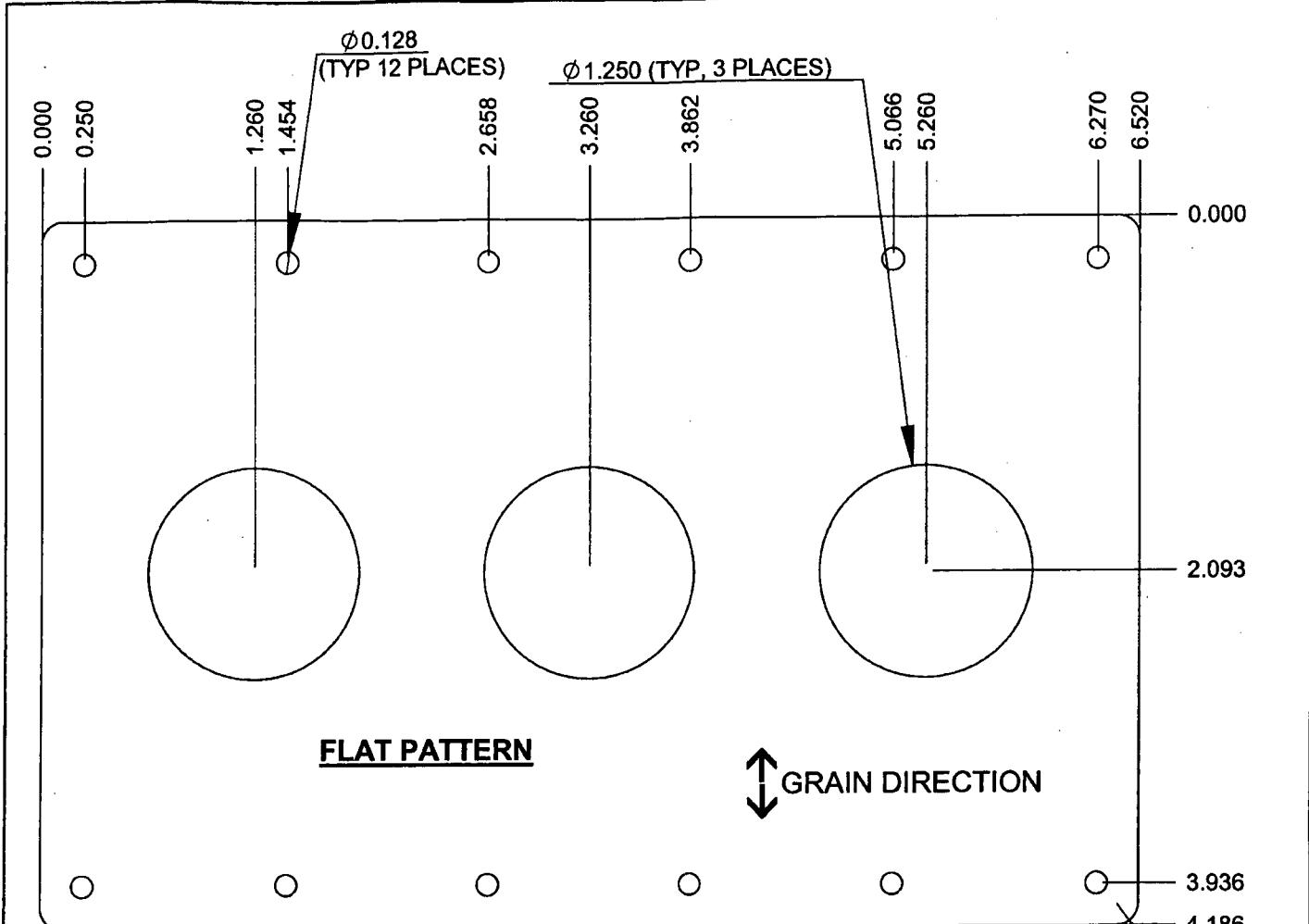
RELEASED
02.09.20

DART



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CHECKED	APPROVED	DRAWING NO. D3065
DATE	02.09.11	TITLE STEP LEG ASSEMBLY

REV. A
SHEET 3 OF 5
SCALE
1:1



~~UNDER REVIEW~~

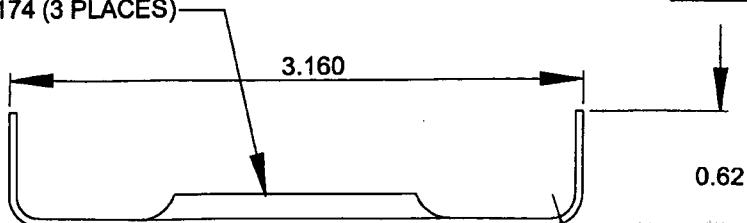
06.06.02 (D)

material change

FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

OK

06.06.15



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BEND DETAIL

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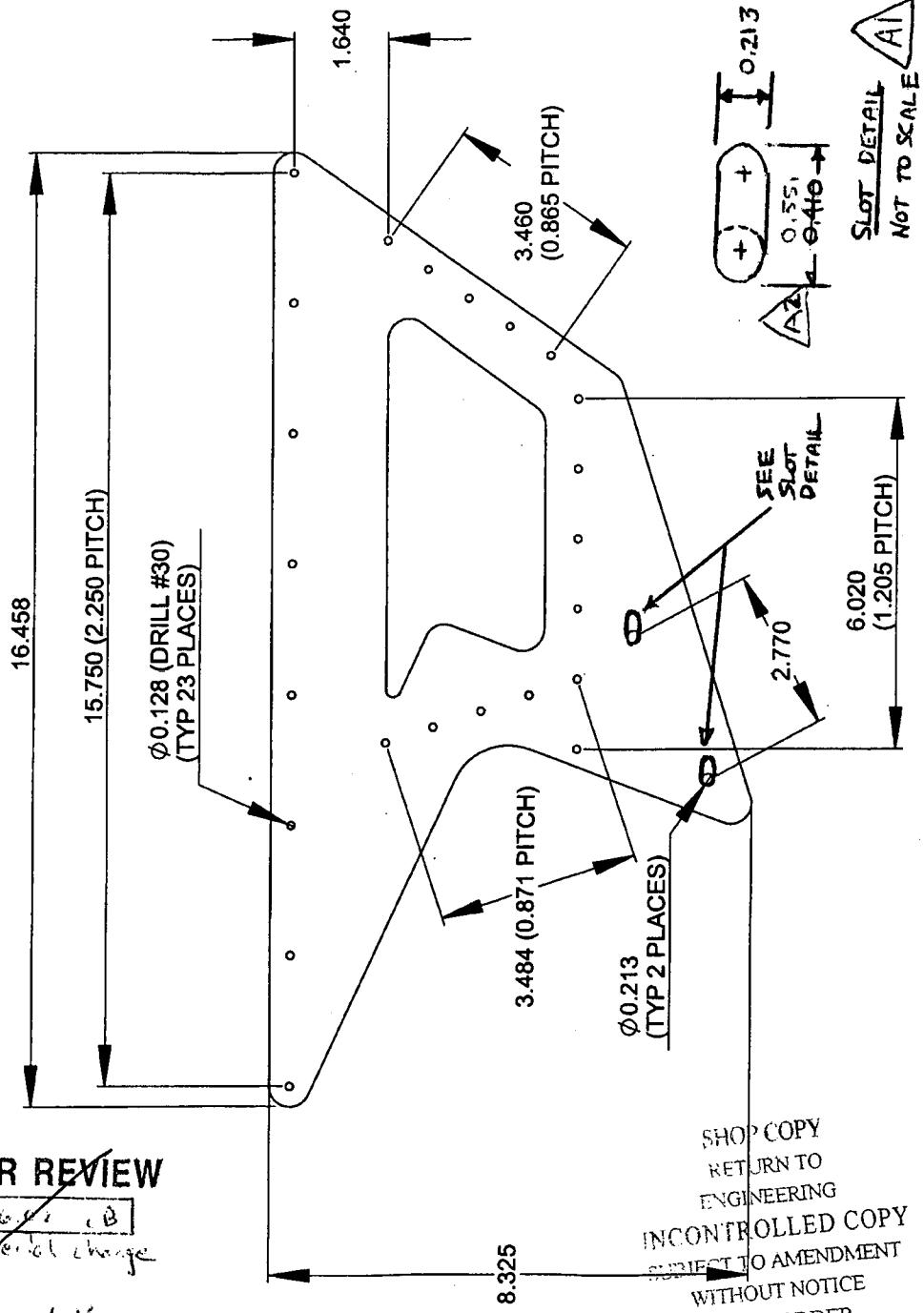
WORK ORDER
NO. 27590 D

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CHECKED ✓	APPROVED ✓	DRAWING NO. D3065	REV. A	SHEET 4 OF 5
DATE 02.09.11	TITLE STEP LEG ASSEMBLY	SCALE 1:3		



D3065-5 STEP LEG

- D3065-5 STEP LEG**

1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

~~UNDER REVIEW~~

~~Q-06-01 B~~
material charge

Q 06.06.15

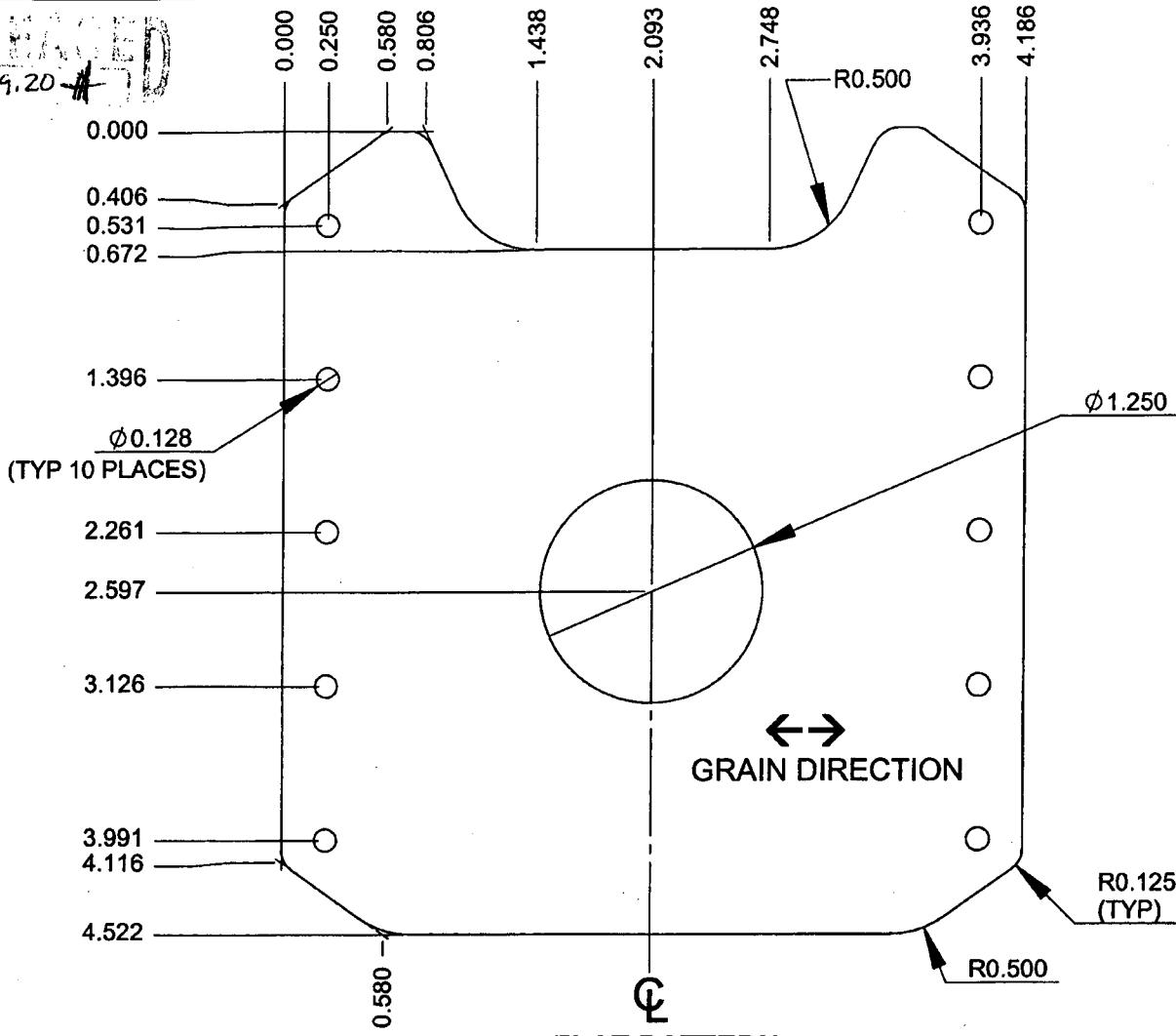
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CHECKED	APPROVED	DRAWING NO. D3065
DATE	02.09.11	REV. A SHEET 5 OF 5 TITLE STEP LEG ASSEMBLY SCALE 1:1

~~RELEASER~~
02.09.20

**UNDER REVIEW**

06.06.15 (B)
material change

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3SN040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	27590-D
Description:	Part Number:	3065-7
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by: <u>M. - M.</u>	Audited by: <u>J.</u>	Prototype Approval: <u></u>
Date: <u>06.07.10</u>	Date: <u>06.07.11</u>	Date: <u></u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	